

**\*76748\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*8\***

**Cust Item ID:**

**\*g\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Date: 11-11-21

### Tooling:

Date:

Stop \*NR2\*

**QC:**

**Date:**

**SPC (Y/N):**

Date:

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D2661	Rev E

0.00

\*100\*

## HAAS CNC VERTICAL MACHINING #1

HAAS 1

## Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number  
MACHINE AS PER DWG AND FOLIO FB073

32 11-12-111

FOLIO REV: 44  
DWG REV: 1

110

0.00

\*110\*

### CONVENTIONAL MILLING MACHINE

Mill Conv

## Memo

0.00

### Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

DL 11-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D:

Dart Aerospace Ltd

W:

I:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

F:

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

N:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

Monday, November 21, 2011 10:19:19 AM

**\*76748\***

**\*D2661-1\***

**Required Date:** 1/10/2012

**Required Qty: 8.00**

**Comments:** IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	8			

**\*D6101-003\***

Saddle Billet, 7075

**Location**

**Loc Qty**

**Loc Code**

MAT040

105

72226

8

73775

36

73780

7

74650

54

MAT44

29

72226

2

73769

**1**

➔ 74680

26

80

B.A 11/12/00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 76748
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2661-1
<b>Inspection Dwg:</b> D2661 Rev. D-E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		-.126	.125	-.124	-.124		
B	0.100	0.140		-.119	-.120	-.120	-.120		
C	1.125	1.145		1.132	1.135	1.136	1.137		
D	0.615	0.685		-.685	-.685	-.685	-.685		
E	0.240	0.260		-.250	-.247	-.247	-.248		
F	1.313	1.343		1.320	1.322	1.323	1.324		
G	0.210	0.230		-.218	-.219	-.220	-.221		
H	0.100	0.180		-.140	-.140	-.140	-.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.575	1.577	1.578		
K	0.235	0.240		-.237	-.237	-.237	-.237		
L	0.100	0.120		-.110	-.110	-.110	-.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		-.512	-.512	-.512	-.512		
O	5.990	6.010		5.999	5.999	5.999	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		-.313	-.313	-.313	-.313		
S	0.315	0.322		-.316	-.316	-.316	-.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		-.797	-.797	-.798	-.797		
W	0.540	0.560		-.550	-.548	-.550	-.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		-.257	-.257	-.257	-.257		
Z	0.912	0.932		-.920	-.919	-.921	-.921		
AA	0.490	0.510		.499	.497	.498	.500		
AB	0.178	0.198		-.188	-.188	-.188	-.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: JH	Audited by: amf
Date: 11-12-11	Date: 11/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 76748
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2661-1
<b>Inspection Dwg:</b> D2661 Rev. D E	<b>Page 1 of 1</b>

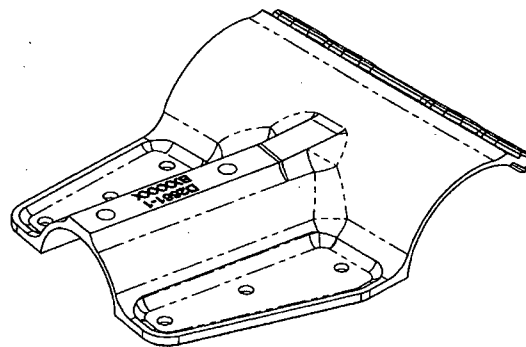
Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		-.125	-.126	-.126	-.126		
B	0.100	0.140		-.120	-.120	-.120	-.120		
C	1.125	1.145		1.137	1.134	1.134	1.134		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		-.221	-.250	-.250	-.250		
F	1.313	1.343		1.324	1.323	1.324	1.324		
G	0.210	0.230		-.221	-.220	-.221	-.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.577	1.574	1.575	1.575		
K	0.235	0.240		-.237	-.237	-.237	-.237		
L	0.100	0.120		-.110	-.110	-.110	-.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.999	5.997	5.999	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		-.313	-.313	-.313	-.313		
S	0.315	0.322		-.316	-.316	-.316	-.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.798	.797	.800	.799		
W	0.540	0.560		-.549	-.550	-.550	-.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		-.257	-.257	-.257	-.257		
Z	0.912	0.932		.920	.921	.919	.918		
AA	0.490	0.510		.499	.498	.497	.499		
AB	0.178	0.198		-.188	-.188	-.188	-.188		
AC									
AD									
AE									
AF									
Accept/Reject									

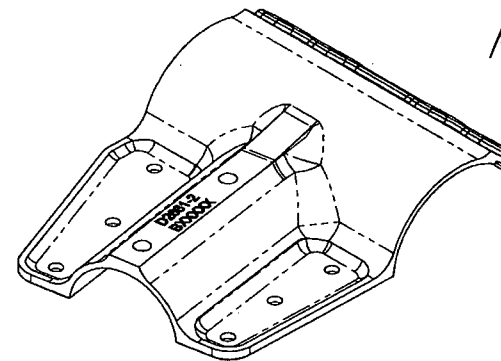
Measured by:	SL
Date:	11-12-11

Audited by:	amf
Date:	11/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	



**D2661-1 SADDLE, OUTSIDE, LH**



**D2661-2 SADDLE, OUTSIDE, RH**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A WORK ORDER  
WITHOUT NOTICE  
WORK ORDER  
NO. 76-748

*R11-11-21*

**RELEASED**  
R 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.318 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9085	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	<i>JP</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JP</i>	D2661	SHEET 1 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>           COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.         </small>	

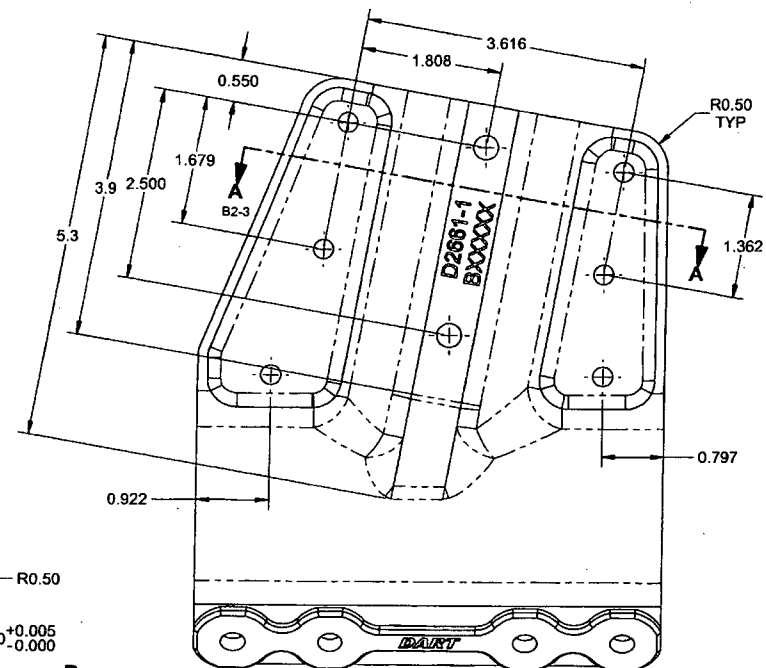
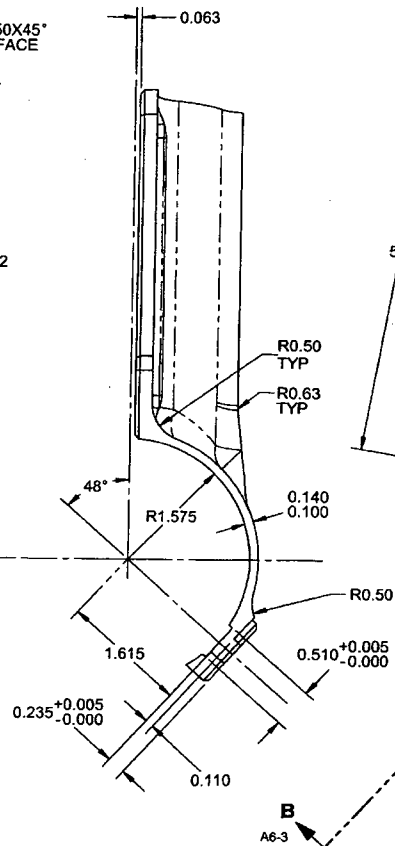
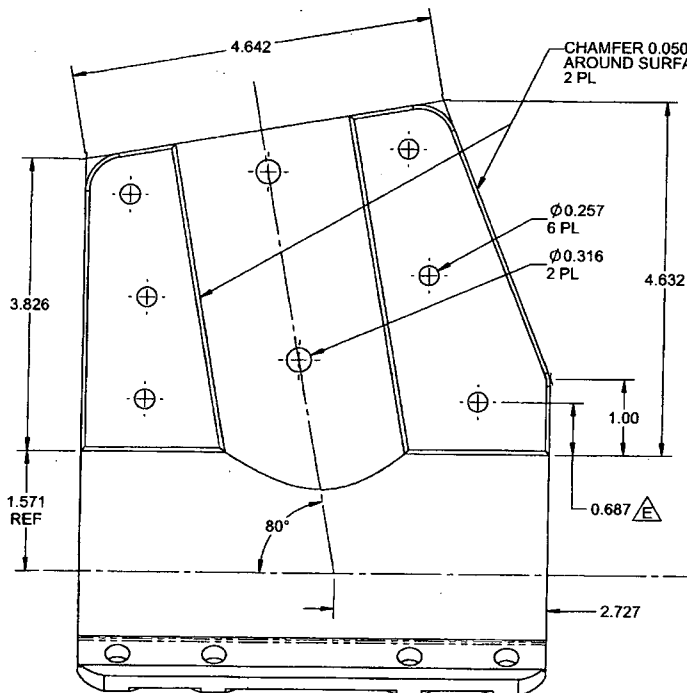
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D2661-1 SADDLE, OUTSIDE, LH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. <b>D2661</b>	REV. E
MFG. APPR.		TITLE <b>SADDLE, OUTSIDE</b>	SHEET 2 OF 5
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
DATE	11.10.31	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED  
R 2011-11-16

76748

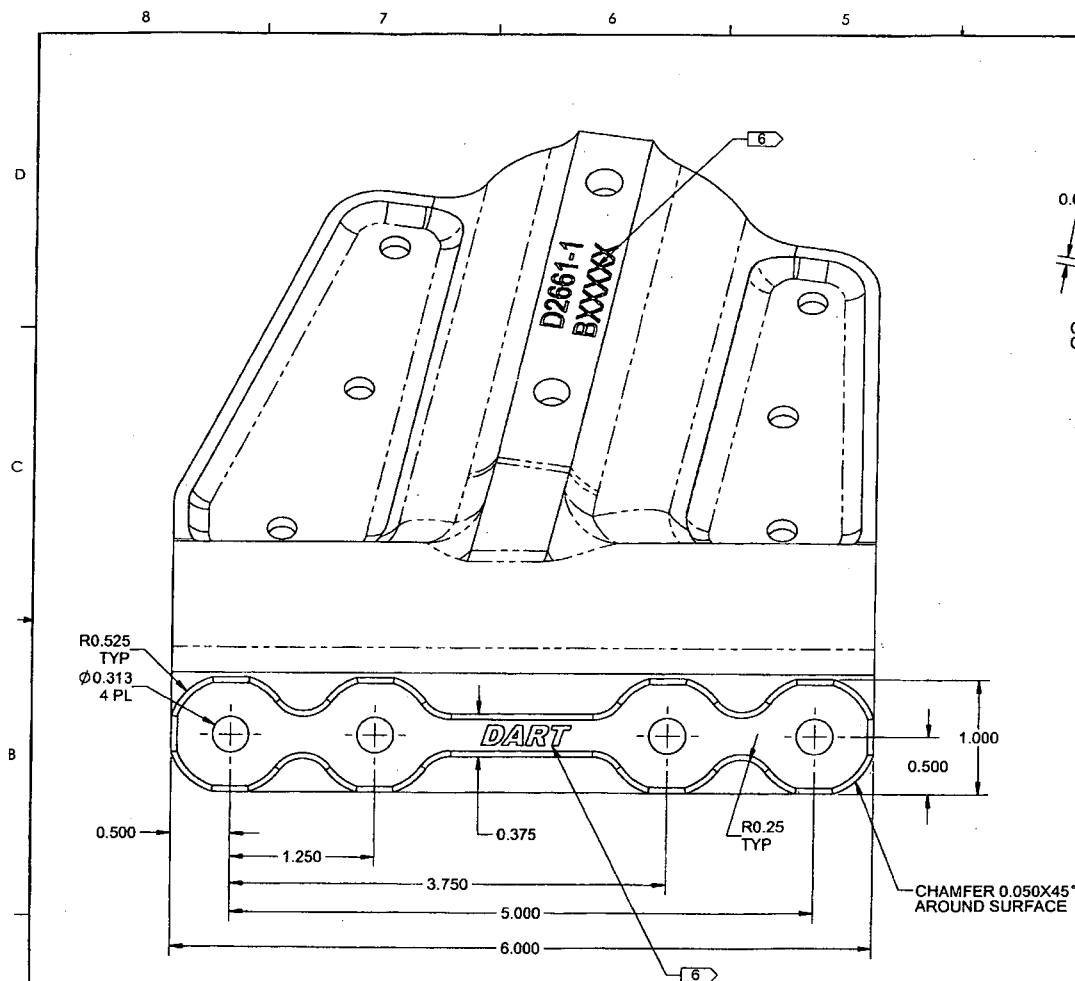
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

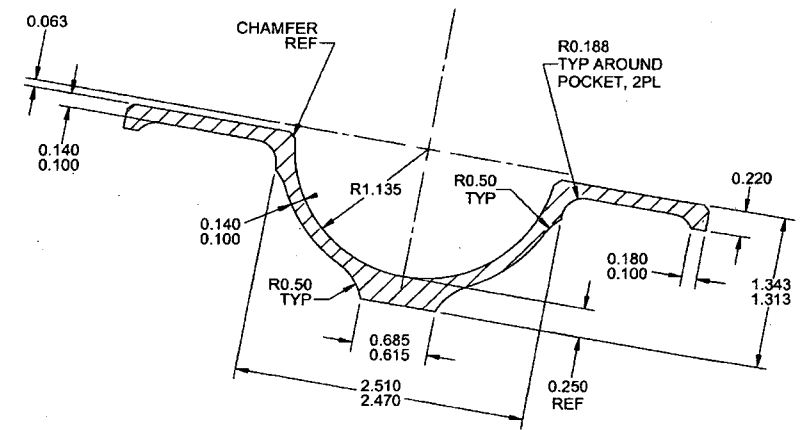
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



VIEW B-B  
SCALE 1.5X  
VIEW ROTATED  
A4-2



VIEW A-A  
SCALE 1.5X  
C3-2

76748

RELEASED  
R 2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	AS	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2661	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DOWNLOADED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

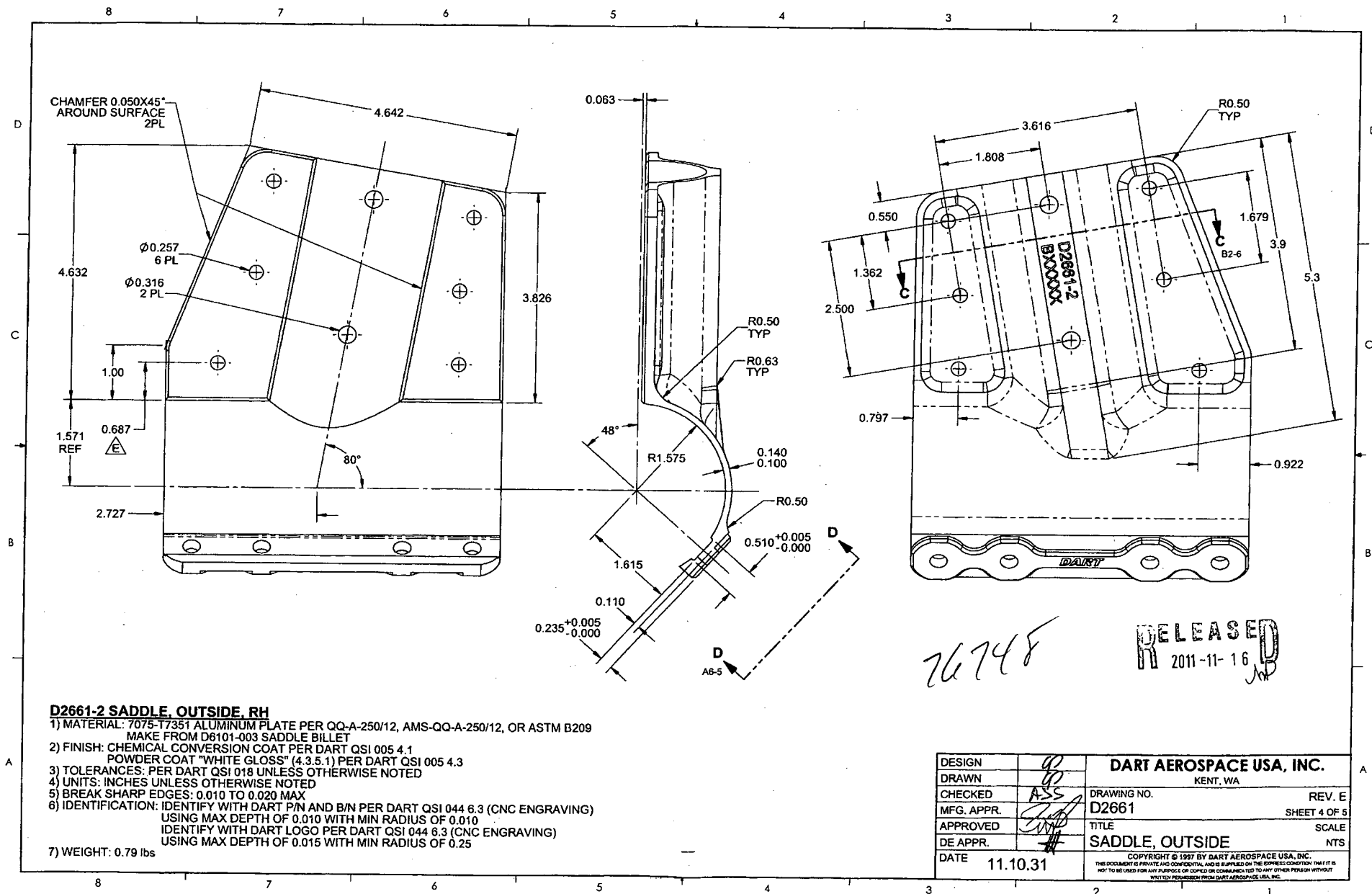
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





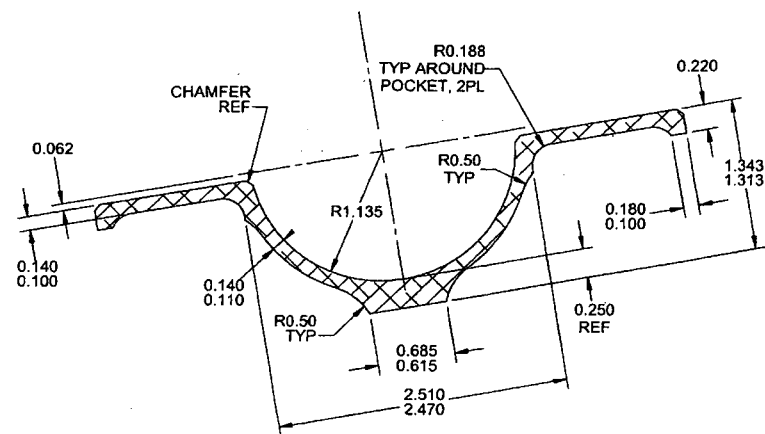
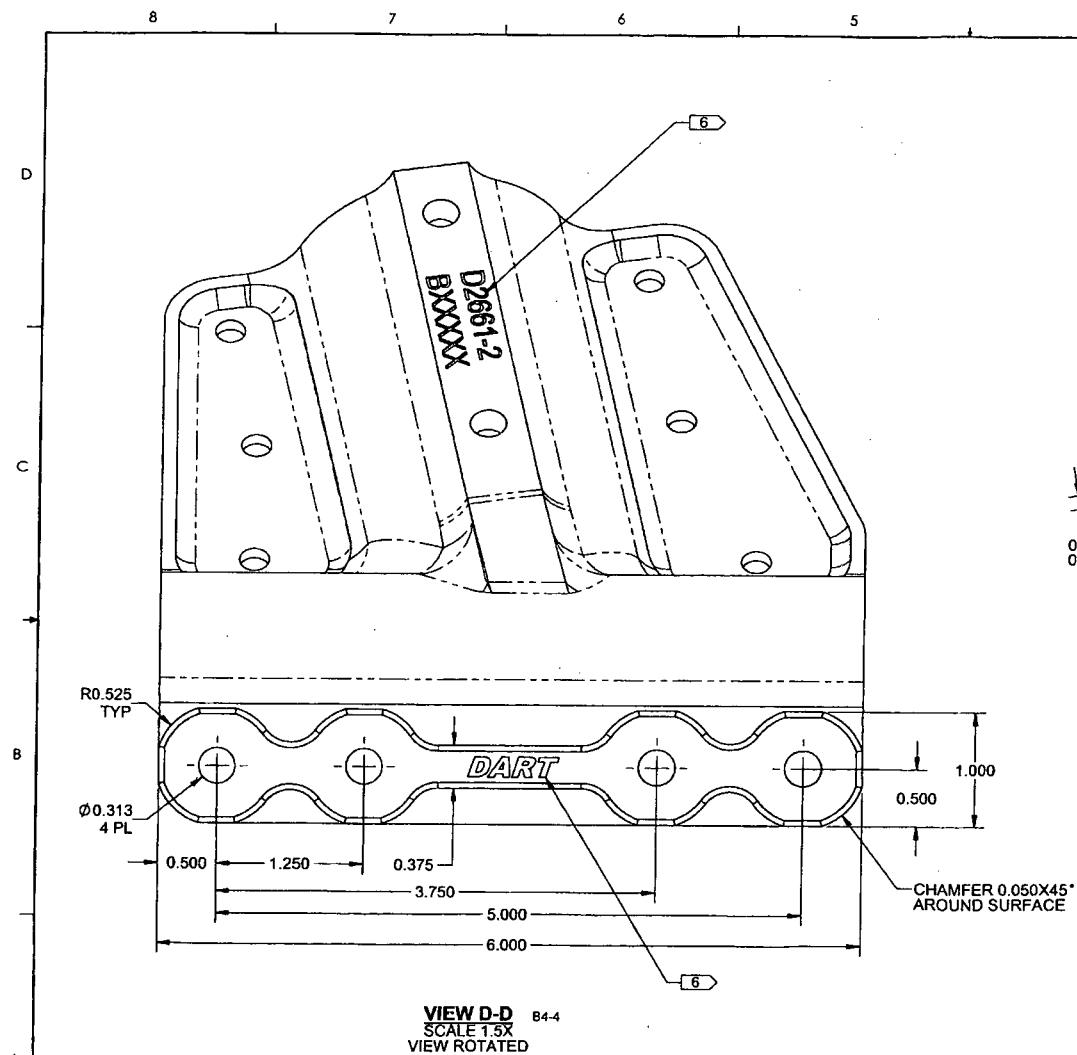
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**SECTION C-C** C1-4  
SCALE 1.5X

DESIGN	gp	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	gp	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	gwp	D2661	SHEET 5 OF 5
APPROVED	gwp	TITLE	SCALE
DE APPR.	gwp	<b>SADDLE, OUTSIDE</b>	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries